

17/9/22

Work Order ID 166321

166321

Friday, September 15, 2017 9:29:18 AM

Item ID: D4884-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: End Fitting, Eye
Start Date: 9/15/2017 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 10/11/2017 Req'd Qty: 4.00 *4* Customer:
Reference: 5/032346

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4884	REV A								

105 2.93
105
Doosan Memo 0.50 4 0 DAS 33 9-89 17/09/16
Doosan Lathe -Machine blank as per Machinist's turning detail, folio+drawing D4884-1.

115 0.49
115
HAAS 5AXIS Memo 0.98 4 0 DAS 08 9-89
HAAS CNC vertical machine #5 Mill as per folio FB509. B.A 17-09-23
Dwg. rev: A
Folio rev: AA

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
117 *117* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.04		B.F. 17-09-23		4	φ		DAS 08 9-89
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.08				4	φ		DAS 49 9-89 17/09/25
130 *130* Outsource2 Outsource process - NDT	Outsource process - NDT per QSI038 4.1 Memo ISSUE P/O : <u>37837</u> C OF C IS REQUIRED	0.00 288.00				4		SEP 26 2017	DAS 13 9-89

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Item ID: D4884-1 Accept ***N900040100*** Setup Start ***NS1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Receive & Inspect for Damage & Mat'l Certs	0.00							
140									
Packaging	Memo	0.08							
Packaging									
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.08							
Quality Control									
160	Identify as per dwg & Stock Location: 54134	0.00							
160									
Packaging	Memo	0.04							
Packaging	IDENTIFY AS PER QSI 044 6.1								

4x SP 17-9-26

4

SEP 27 2017

DAS 6 170

4

SEP 27 2017

74

Work Order ID 166321

Friday, September 15, 2017 9:29:18 AM

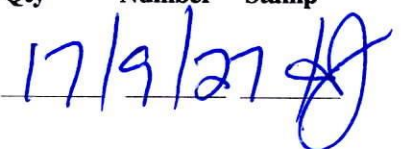
166321

Page 4

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.40							
Quality Control									

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D4884-1

Required Date: 10/11/2017

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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DAS

33
9-89

17/09/16

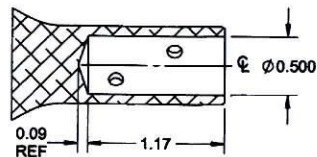
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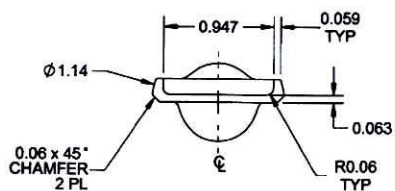
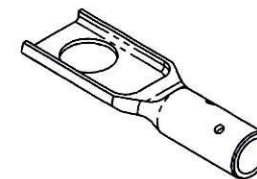
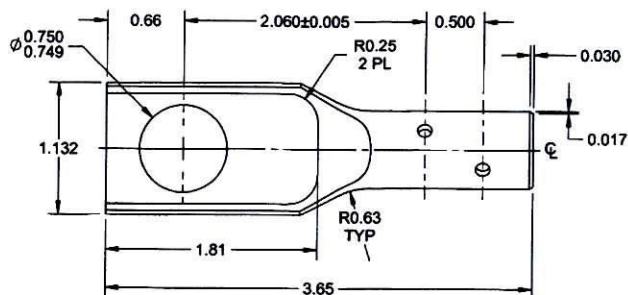
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102

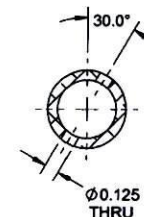
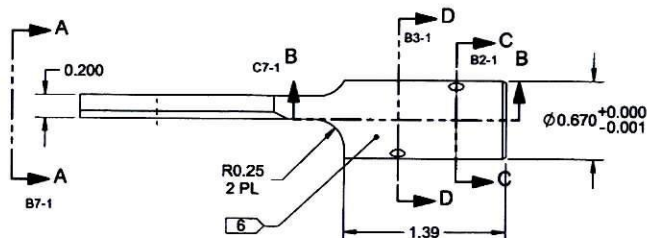
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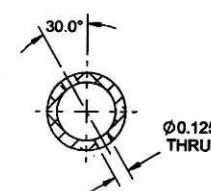
SECTION B-B CS-1



VIEW A-A B6-1



SECTION C-C C4-1



SECTION D-D C5-1

D4884-1 END FITTING, EYE

RECEIVED
11 2013-12-12

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYP 630 SS ROUND BAR, H900 CONDITION PER AMS 5643/ASTM A564 DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166321

APPROVED

A NEW ISSUE		RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	DC		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	13.12.01		

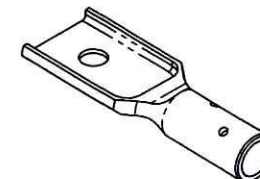
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4884

TITLE
END FITTING

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SEP 15 2017



NOTES:

NOTES:
1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
PART SPEC M17-4-R

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

7) WEIGHT: 0.14 lbs

8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED	DESIGN	RF	DART AEROSPACE LTD	
	DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	DC	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D4884	SHEET 2 OF 2
	APPROVED	HS	TITLE	SCALE
	DE APPR.	#	END FITTING	N/T
	DATE	13.12.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND NOT BE LOANED OR REPRODUCED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT	

DART AEROSPACE LTD		Work Order: 166321
Description: End Fitting, Eye		Part Number: D4884-1
Inspection Dwg: D4884	Rev: A	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+0.006/-0.001	0.504	✓		MJP-64	vern
1.17	+/-0.030	1.165	✓			
R0.63	+/-0.030	0.063	✓			
0.500	+/-0.005	0.500	✓			
0.030	+/-0.010	0.030	✓			
0.017	+/-0.010	0.017	✓			
Ø0.670	+0.000/-0.001	0.669	✓			
30°	+/-0.5°	30°	✓			
Ø0.125	+0.004/-0.001	0.126	✓			
30°	+/-0.5°	30°	✓			
Ø0.125	+0.004/-0.001	0.126	✓			
Ø1.14	+/-0.030	Ø1.139	✓		Mic	GA-02
1.132	+/-0.010	1.134	✓		Vern	GA-13
Ø0.750	+0.000/-0.001	Ø0.7493	✓		T-6/Mic	ref. / GA-03
0.66	+/-0.030	0.6615	✓		H-6	31006
2.060	+/-0.005	2.0647	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-6	ref.
1.81	+/-0.030	1.8105	✓		H-6	31006
3.65	+/-0.030	3.658	✓		"	"
0.06 x 45°	+/-0.030 x +/-0.5°	0.062x45°	✓		Vern	GA-13
0.947	+/-0.010	0.947	✓		"	"
0.059	+/-0.010	0.060	✓		"	"
0.063	+/-0.010	0.064	✓		Mic	GA-03
R0.06	+/-0.030	R0.063	✓		R-6	ref.
0.200	+/-0.010	0.203	✓		Vern	GA-13
R0.25	+/-0.030	R0.250	✓		R-6	ref.
1.39	+/-0.030	1.397	✓		H-6	31006

Measured by: 33 9-89	Checked by: 49 9-89	QC Inspector:
Date: 17/09/16	Date: 17/09/16	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37837**

Purchase Order Date 9/22/2017

PO Print Date 9/26/2017

Page Number 1 of 10

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-678-5636

Ship To Contact
Ship To Phone
Ship Via: Delivered
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	71401-45	procurement quality clauses	9/26/2017 No 9/26/2017		1.00	\$0.00	\$0.00
Line Total:							\$0.00
2	163756	D4885-3 END FITTING	9/26/2017 Yes 9/26/2017		4.00	\$0.00	\$0.00
LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417							
Line Total:							\$0.00
3	166321	D4884-1 END FITTING	9/26/2017 Yes 9/26/2017		4.00	\$0.00	\$0.00
LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417							

Note:

9/26/2017

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**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 380

WO #: MWO33395	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO37837
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 8 CROSSTUBES AND 8 FITTINGS AS PER PO37837

1 END FITTING, EYE , ITEM ID# D4884-1 , W/O# 166321

SPR-9-26

1 END FITTING , ITEM ID# D4885-3 , W/O# 163756

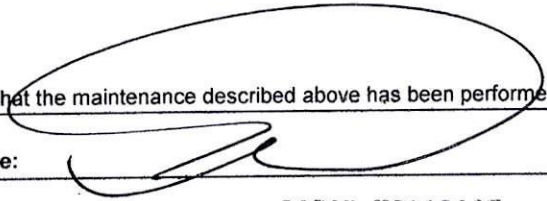
4 AFT CROSSTUBES , ITEM ID# D412-664-203 , W/O# 164205, 164206, 161887, 161888

4 AFT CROSSTUBES , ITEM ID# D119-796-241 , W/O# 162392, 165570, 165571, 165572

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , EMU. MPO15896, DEV. MPO11715 , UV LIGHT M-20142						SEP 25 2017	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

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I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: SEP 25 2017
Name: RAFIK MELIKIAN		